



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBH9928-2-1
Job Sheet 168620



Part No: RBH9928-2-1

Job Qty: 3 ea

Part Name: Tab Bender



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/20/17

Job Tracking No:

Due Date: 11/24/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBH9928-2 Rev 10 U/R IPP Rev A 17.11.15 New issue DP Verify DD/IPP Rev B 17.11.20 DWG Rev K 17.11.20 DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		11/23/17	0.00	0.00	Start Up Machining-3		18/01/12
95	Bandsaw	3 pcs		11/23/17	0.00	0.30	Bandsaw1		18/01/12
100	Mori Seiki	3 pcs		11/24/17	0.00	3.00	MORI NV5000-2		18/01/12
110	QC	3 pcs		11/24/17	0.00	0.00	QC2 Machining-3		18/01/12
120	QC	3 pcs		11/24/17	0.00	0.00	QC8 Machining-4		18-01-22
130	Brake NC	3 pcs		11/24/17	0.00	0.00	Brake NC 1		38
140	QC	3 pcs		11/24/17	0.00	0.00	QC5		38
150	Outsource	3 pcs		11/24/17	0.00	0.00	Outsource4		AT 18/02/12
160	Packaging	3 pcs		11/24/17	0.00	0.00	Packaging2		AT 18/02/12
170	QC	3 pcs		11/24/17	0.00	0.00	QC6		38
175	Packaging	3 pcs		11/24/17	0.00	0.00	Packaging3		38
180	QC21-SA	3 Ea		11/24/17	0.00	0.00	QC21		DAS 21 9-00 FEB 13 2018

Part Op 95 - Cut blanks to 8.00"

Descriptions: 100 - 1-Machine as per folio FB 676 FOLIO REV: _____ DWG REV: _____ 2-Deburr NOTE;

Machine RBH9928-2-3 at same time

120 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

130 - Form as per DWG. -Remove bending marks -Tumble to remove buffer marks

150 - Issue P/O to ATG : PO 038921 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required

JAN 31 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B0.250X6.250	2	0	0	0

Part Specifications

Specifications could not be found.

S25654 → 3032381

Plex 11/20/17 10:14 AM Dart.lajeunesse.marie

2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order Part N NCR I Date : 	 S032393 Tab Bender	DISPOSITION 	AGAINST DEPARTMENT/PROCESS <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>Cross tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☐</td> </tr> <tr> <td>Ill Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>ishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>posite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table> MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	Cross tube	☐	Water Jet	☐	Engineering	☐	Ill Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	ishing	☐	Rec/Store/Packaging	☐	Other	☐	posite	☐	Supplier	☐																																																																																																														
Cross tube	☐	Water Jet	☐	Engineering	☐																																																																																																																																		
Ill Fab	☐	Prod. Eng. Coord.	☐	Quality	☐																																																																																																																																		
ishing	☐	Rec/Store/Packaging	☐	Other	☐																																																																																																																																		
posite	☐	Supplier	☐																																																																																																																																				
PART NO: RBH9928-2-1 Original Serial #: S032393 Revision: Operation: Start up Operation Change No:		01/15/18 Job No: 168620																																																																																																																																					
Root Cause <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>Environment</td><td>☐</td> <td>No Re-verification</td><td>☐</td> <td>Pressure/Forced</td><td>☐</td> <td>Temperature/Cure</td><td>☐</td> </tr> <tr> <td>Design</td><td>☐</td> <td>Operator</td><td>☐</td> <td>Bending</td><td>☐</td> <td>Set-up</td><td>☐</td> </tr> <tr> <td>Doc/Data</td><td>☐</td> <td>Offset/Setup</td><td>☐</td> <td>Centre Not Concentric</td><td>☐</td> <td>BOM/Route</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> <td>Supplier</td><td>☐</td> <td>Cracks</td><td>☐</td> <td>Broken/Damage/Defect</td><td>☐</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td> <td>Training</td><td>☐</td> <td>Crimp/Kink/Ripple/Wave</td><td>☐</td> <td>Inspection Incomplete/Unqualified</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> <td>Use for Testing</td><td>☐</td> <td>Cuffs</td><td>☐</td> <td>Contamination</td><td>☐</td> </tr> <tr> <td>Internal Transport</td><td>☐</td> <td>Poor Information</td><td>☐</td> <td>Crushing</td><td>☐</td> <td>Countersink</td><td>☐</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td> <td>Rushing</td><td>☐</td> <td>Heat Treat</td><td>☐</td> <td>Cut Too Short</td><td>☐</td> </tr> <tr> <td>LOA</td><td>☐</td> <td>Product Improvement</td><td>☐</td> <td>Wave/Twist in Tube</td><td>☐</td> <td>Instructions Incomplete/Unclear</td><td>☐</td> </tr> <tr> <td>Substation</td><td>☐</td> <td>Process Improvement</td><td>☐</td> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td> <td>Manufacturing Process</td><td>☐</td> <td colspan="4" rowspan="2">OTHER :</td> </tr> <tr> <td>Misidentified</td><td>☐</td> <td>Past Due</td><td>☐</td> </tr> </table>		Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Design	☐	Operator	☐	Bending	☐	Set-up	☐	Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Past Expiry Date	☐	Manufacturing Process	☐	OTHER :				Misidentified	☐	Past Due	☐	CATEGORY <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>Power Loss/Surge</td><td>☐</td> <td>Positioned Wrong</td><td>☐</td> </tr> <tr> <td>Folio/Program</td><td>☐</td> <td>Outside Dimensions</td><td>☐</td> </tr> <tr> <td>Grain</td><td>☐</td> <td>Over/Under tolerance</td><td>☐</td> </tr> <tr> <td>Weld</td><td>☐</td> <td>Part Incorrect</td><td>☐</td> </tr> <tr> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Out of Sequence</td><td>☐</td> <td>Part Moved</td><td>☐</td> </tr> <tr> <td>Off-set</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Mislabeled</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>Fit/Function</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Misaligned/off center</td><td>☐</td> <td>Turning Sequence</td><td>☐</td> </tr> </table>		Power Loss/Surge	☐	Positioned Wrong	☐	Folio/Program	☐	Outside Dimensions	☐	Grain	☐	Over/Under tolerance	☐	Weld	☐	Part Incorrect	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Out of Sequence	☐	Part Moved	☐	Off-set	☐	Drawing	☐	Mislabeled	☐	Finish	☐	Fit/Function	☐	Misread	☐	Misaligned/off center	☐	Turning Sequence	☐
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐																																																																																																																																
Design	☐	Operator	☐	Bending	☐	Set-up	☐																																																																																																																																
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐																																																																																																																																
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐																																																																																																																																
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐																																																																																																																																
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐																																																																																																																																
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐																																																																																																																																
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐																																																																																																																																
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐																																																																																																																																
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐																																																																																																																																
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :																																																																																																																																			
Misidentified	☐	Past Due	☐																																																																																																																																				
Power Loss/Surge	☐	Positioned Wrong	☐																																																																																																																																				
Folio/Program	☐	Outside Dimensions	☐																																																																																																																																				
Grain	☐	Over/Under tolerance	☐																																																																																																																																				
Weld	☐	Part Incorrect	☐																																																																																																																																				
Wrong Stock Pulled	☐	Part Lost/Missing	☐																																																																																																																																				
Out of Sequence	☐	Part Moved	☐																																																																																																																																				
Off-set	☐	Drawing	☐																																																																																																																																				
Mislabeled	☐	Finish	☐																																																																																																																																				
Fit/Function	☐	Misread	☐																																																																																																																																				
Misaligned/off center	☐	Turning Sequence	☐																																																																																																																																				

DQA: _____ Date: _____

0.100 1.277

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

DART AEROSPACE LTD		Work Order:	168426
Description: TAB BELDER		Part Number:	RB49928-2-1
Inspection Dwg:	Rev: K		Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:	<i>anh</i>	Checked by:	<i>20</i> <i>0-80</i>	QC Inspector:	
Date:	<i>18/01/12</i>	Date:	<i>18-01-22</i>	Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	K.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038921

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	168598	RBH9928-2-1	Roof Doubler Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 647.0100 Rev. A Tab Bender -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	4 pcs	0 pcs	4 pcs	\$7.30/pcs	\$29.20
10	168599	RBH9928-2-3	Clamp -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	4 pcs	0 pcs	4 pcs	\$7.30/pcs	\$29.20
11	168620	RBH9928-2-1	Tab Bender -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	3 pcs	0 pcs	3 pcs	\$7.30/pcs	\$21.90
12	168622	RBH9928-2-3	Clamp -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	3 pcs	0 pcs	3 pcs	\$7.30/pcs	\$21.90
13	168651	RBH9928-2-1	Tab Bender -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	3 pcs	0 pcs	3 pcs	\$7.30/pcs	\$21.90
14	168654	RBH9928-2-3	Clamp -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	3 pcs	0 pcs	3 pcs	\$7.30/pcs	\$21.90
15	168944	RBH9928-12-3	Tab Bender -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2,	Firmed	2/9/18	1 pcs	0 pcs	1 pcs	\$7.30/pcs	\$7.30



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914609

Date: 09-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
5 ea	Part: RBW109-3101-58-2-3 Hammer Head Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils) Water Sealant Job: 22466		Rev: 3 PO: PO 038921 Line: 6
3 ea	Part: RBH9928-2-1 Tab Bender Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22471		Rev: K FO: PO038921 Line: 11
3 ea	Part: RBH9928-2-3 Clamp Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22474		Rev: K PO: PO038921 Line: 14
4 ea	Part: RBW109-3101-58-2-7 Handle Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils) Water Sealant Job: 22467		Rev: 3 PO: PO038921 Line: 7
4 ea	Part: RBH9928-2-1 Tab Bender Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22469		Rev: K PO: PO038921 Line: 9
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements.			
Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914609

Date: 09-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		OUR TRUCK
Quantity	Description	
	Date: <u>02/02/2018</u>	
	Certified Signature: <u>[Signature]</u>	
	Receiver Signature: _____	
A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.		
Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		
Made in Canada.		